

Work Order ID 127604

127604

Page 1

December-17-14 1:40:02 PM

Item ID: D2066 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Arm
 Start Date: 12/17/14 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 12/17/14 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: MLS Date: 14-12-23 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2066	Rev C

100	Small Fab	0.00							
100									
Small Fab	Memo	0.00							
Small Fab	1-Punch 1/2" OD x .049" Wall 304/316 SS Seamless Tube (Ref QSI 017 4.1.1.2) as per Dwg D2066 (per D2727) Use punch Jig DT8012								
	2-Slide on parts per Dwg and W/O for D2676-043								
	3-Punch other end to length (28.62") as per Dwg D2066								
	4-Bend per Dwg D2066								
	5-Drill using DT9034								

110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	Memo	0.00							
Quality Control									

4X DAS JAN 12 2015
28
9-89

(4) DAS JAN 13 2015
38
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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December-17-14 1:40:02 PM

Page 2

Setup Start *NS1*

Stop *NS2*

Stop *NS2*

4

4

Customer:

Run Start *NR1*

Stop ***NR2***

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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0.00

0.00

Memo

Packaging

JAN 14 2015

DAS
66
9-89

QC21- Final Inspection - Work Order Release

0.00

0.00

QC

Memo

Quality Control

MCS 15-01-14
MF
15-1-14

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Picklist Print

December-17-14 1:40:01 PM

Page 1

Work Order ID: 127604

127604

Parent Item: D2066

D2066

Parent Item Name: Arm

Start Date: 12/17/14

Required Date: 12/17/14

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP D 02.03.18Added pick list NG
IPP E 07.10.03 removed p/c EC verified by: DD
IPP Rev:F 08-07-24 revC as per dwg (ecn 08-504) DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2052 *D2052* Bracket		Manufactured	No			100	Each	49.0000	2	8		DAS 28 9-89	JAN 12 2015
**													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		49							
				101643		12							
				108808		37							
D2054 *D2054* Bushing - Delrin		Manufactured	No			100	Each	72.0000	2	8		DAS 28 9-89	
**													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		72							
				104846		27							
				109091		45							
D2055 *D2055* Clamp		Manufactured	No			100	Each	42.0000	1	4		DAS 28 9-89	
**													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		42							
				105553		10							
				105730		20							
				92691		4							
				95397		8							

DQA: _____ Date: _____



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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

December-17-14 1:40:01 PM

Page 2

Work Order ID: 127604

127604

Parent Item: D2066

D2066

Parent Item Name: Arm

Start Date: 12/17/14

Required Date: 12/17/14

Start Qty: 4.00

Required Qty: 4.00

D2056

Manufactured No

100

Each

25.0000

1

4

D2056

Bell Crank Assembly

DAS
28
9-83

Location

Loc Qty

Loc Code

GA

25

109921

20

92742

2

97798

3

M304TR0.500W.049

Purchased

No

120

f

274.0000

2.386

10.04632

M304TR0 500W 049

304 RD Tube .500 x .049W

DAS
28
9-83

JAN 12 2015

Location

Loc Qty

Loc Code

GA002

274

M127937

14

M128833

260

MS21042L3

Purchased

No

100

Each

998.0000

2

8

MS21042L 3

Nut

DAS
28
9-83

Location

Loc Qty

Loc Code

FP001

489

M130922

489

GA

33

M128754

33

ST305

473

M130799

473

ST307

3

123900

3

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Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Page 3

Work Order ID: 127604

127604

Parent Item: D2066

D2066

Parent Item Name: Arm

Start Date: 12/17/14

Required Date: 12/17/14

Start Qty: 4.00

Required Qty: 4.00

MS27039-1-18

Purchased

No

100

Each

1,953.000

2

8

MS27039-1-18

DAS

JAN 12 2015

Screw

28
9-89

Location

Loc Qty

Loc Code

ST273A

1872

124326

1872

8

ST284

81

123522

81

NAS1149D0363J

Purchased

No

100

Each

2,128.000

4

16

NAS1149D0363.J

DAS

Washer

28
9-89

Location

Loc Qty

Loc Code

CA

673

m130799

673

FP001

154

m126319

154

GA

810

m128429

810

ST269

491

122378

254

m126319

237

16

DQA: _____ Date: _____



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